

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018349**Date Inspected:** 27-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower / OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #10

This QA Inspector observed the following work in progress

Tower

Heat Straightening:

Heat Straightening being performed on South Tower, Lift 6 Skin E Plate SSD1 –FESA6 -1 -3, 4 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (T) – 11586.

ORTHOTROPIC BOX GIRDER (OBG)

Flux Cored Arc Welding (FCAW):

Weld joint # 014, 015 located on Bike path BK004A2 -026. Welder is identified as 052075. ZPMC Quality

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Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 2 -Plug.

Bay #11

Tower

Flux Cored Arc Welding (FCAW)

Weld joint # 26A located on Lift 6 Skin plate to additional plate ESD1-FGSA6 - 2. Welder is identified as 053316.

ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231-B –U3C-F2.

Weld joint # 7, 8 located on Lift 6 Skin plate to stiffener WSD1-FDSA6 -4. Welder is identified as 205649.

ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 3, 4 located on Lift 6 Skin plate to stiffener WSD1-FDSA6 -4. Welder is identified as 040723 / 205649. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 1 located on Lift 6 Skin plate to stiffener ESD1-FFSA6 -2. Welder is identified as 040736. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Submerged Arc welding (SAW)

Weld joint # 23B located on Lift 6 Skin plate WSD1-FFSA6 -4. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 –B – U3C –S -2.

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint # 6A located on North shaft, Lift 5 Bracket, ND1-BRSA5 -2 . Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – 485 –SMAW -2G (2F) -Repair.

ORTHOTROPIC BOX GIRDER (OBG)

Flux Cored Arc Welding (FCAW):

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Weld joint # 054, 055 located on Bike path BK004A5-019. Welder is identified as 042218. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T - 2132.

Weld joint # 064, 065 located on Bike path BK004A5-019. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T - 2132.

Weld joint # 063, 070 located on Bike path BK004A6-019. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – TC-P4-F.

Weld joint # 078, 080 located on Bike path BK004A6-019. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – TC-P4-F.

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ZPMC Quality Control personnel. The member is identified as Bike path -OBG Component. The component and weld designation identified as follows:

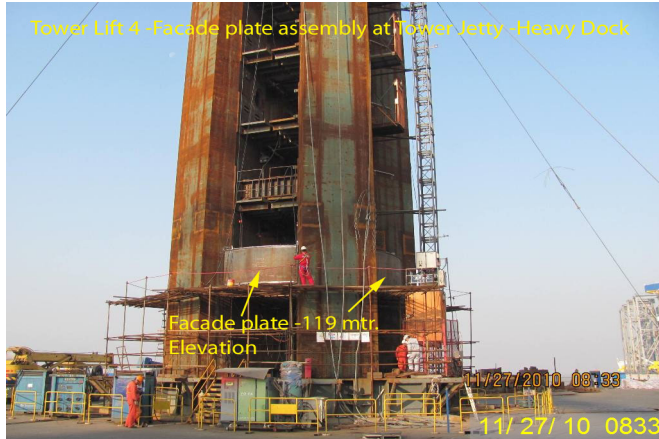
BK004A2-019 – 016, 018

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer